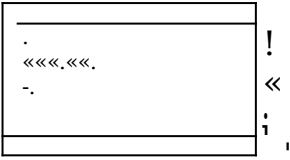


and the shoulder of the head bears against the finished surface of a boss on the jig, it will give the cutting tool almost as rigid a bearing as if the jig metal surrounded the hushing all the way up.

Removable bushings are frequently used for work which must be drilled, reamed, and tapped, there then being one hushing for each of the cutting tools. They are also used when different parts of the same hole are to be drilled out to different diameters, or when the upper portion of the hole is counterbored,

Table II. Dimensions of Lining Bushings

							**
							
A	n	L	4	1.	it!	L	
»i.	li*	lj	I	j«	i*
%	9 id	L•j	l'i	1'«	I	»* 5 n	5ii
?i»	H	**	I n«	I s«		H	2!!
9U	Ujn	RH	J4l	1 4	1	j!«* #i	i?ft
51	H	?4	I 'M*	j	;	J*	i
me	*}ici	?U	t«itl	I "Hit	j	K«1 *	i*
II	I	I	iH	4	i	« u!	i!4
»Me	I tt	H i	I'4	i'j	i	i! i n l	'04
fla	Hi	Hi	I'4 8	i'j	i	i! i n l	il^
I	I'M	I-14	I 7l	1 7l	i	i! i n l	
IHe	•U	•U	«•»..	•?..	i		

or when a lug has to be faced oT. In this case, each tool, of course, has its own guide bushing. Tin* rommon design of removable bushings is shown in Fig. 6. The outside is made to fit the inside of the lining hushing with a nice sliding fit, so that it can be gently pressed into the lining hushing by the hand. The distance /! under the head of the bushing should be the same length as, or longer than, the guide bushing. The thickness *B* of the head varies, of course, according to the size of the bushing. The diameter *C* of the head should be